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D2620**Job Sheet 195726****Part No:** D2620**Job Qty:** 14 pcs**Part Name:** Skidtube, 206 Skidtube**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/30/19**Job Tracking No:****Due Date:** 7/5/19**Created By:** Kimberley Guerin**Type:** Stock**Description:****Note:** DWG REV B IPP D 02.07.26 Change Dwg to rev.B; Updated Location RF**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skid tubes - Bend - 1	14 pcs	7/5/19	7/5/19	0.00	3.68	Skid tubes - Bend		<i>mha</i>
110	QC 5	14 pcs	7/5/19	7/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		<i>BE</i>
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		

**Container No:** S189572**Part:** D2620**Job No:** 195726**Serial No/Batch:** S189572**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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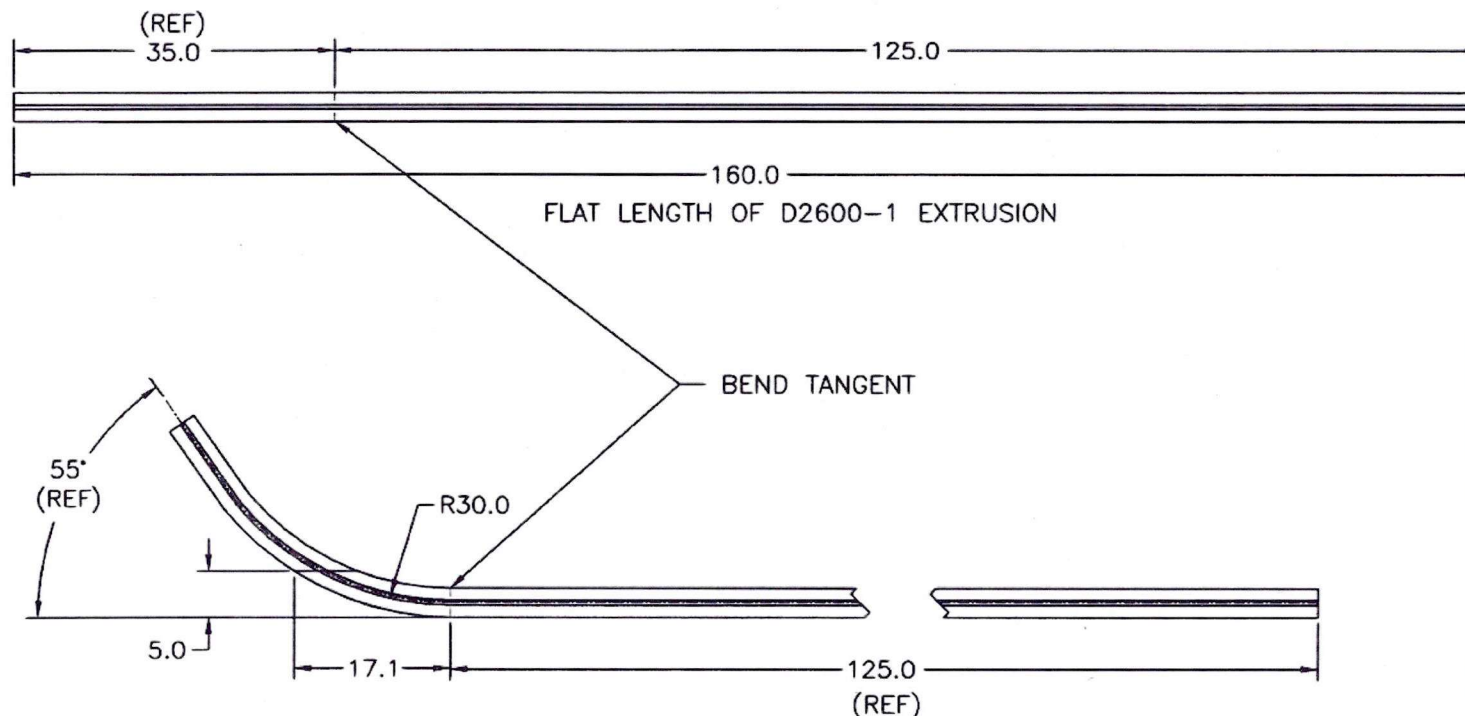
Date: 06/12/19

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	BE
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130 QC 21 - SA	14 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DWG JUN 17 2019
				QC 21 - SA - 53	21
Part Op 100 - Skid tubes - 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2- Descriptions: Cut Fwd end of tube as per Dwg D2620 110 - QC5- Inspect part completeness to step on W/O) 120 - Identify as per dwg & Stock Location: <u>LG002</u> LOCATION : LG002 130 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2600-1-160	Extrusion Round 3" 206	14 pcs (1 ea)	100-Skid tubes - Bend - 1	S113033 (7x)	
				S168228 (7x)	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Skid tubes - Bend - 1	D2600-1-160	14	59	0	
Part Specifications					
Specifications could not be found.					

Plex 5/30/19 9:16 AM Dart.Guerin.Kimberley

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	DATE	TITLE
99.09.10	97.11.07	206 SKIDTUBE BENDING CONTROL
A	97.09.10	NEW ISSUE
B		UPDATE FOR IN-HOUSE BENDING
		SCALE
		1:20

RELEASED
44-04-15 D5